



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5600-1

Job Sheet 185592



Part No: D5600-1

Job Qty: 10 ea

Part Name: Doubler Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5600 REV.A IPP REV:A 18.04.19 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		11/16/18	0.00	0.83	Waterjet - Flow		SC 18/11/01
110	QC	10 pcs		11/16/18	0.00	0.00	QC2 Waterjet-4		SC 18/11/01
120	QC	10 pcs		11/16/18	0.00	0.00	QC8-6		38
130	Brake NC	10 pcs		11/16/18	0.00	0.83	Brake NC 2		38
140	QC	10 pcs		11/16/18	0.00	0.00	QC5		38
150	Outsource	10 pcs		11/16/18			ATG001-VC	10	DEC 17 2018
160	Packaging	10 pcs		11/16/18	0.00	0.00	Packaging2		DEC 17 2018
170	QC	10 pcs		11/16/18	0.00	0.00	QC6		DEC 17 2018
180	SprayPaint	10 pcs		11/16/18	0.00	2.50	Spray Paint		DEC 17 2018
220	QC	10 pcs		11/16/18	0.00	0.00	QC14		DEC 17 2018
230	Packaging	10 pcs		11/16/18	0.00	0.00	Packaging3-2		DEC 17 2018
240	QC21-SA	10 Ea		11/16/18	0.00	0.00	QC21		DEC 17 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Bend as per dwg.

150 - - Issue P/O to Groupe Altech: P/O 041979 - Passivate, QQ-p-35 TYPE VI - Certificate of Conformity is required

160 - Certification of Conformity is required.

180 - PRIME AS PER DWG QSI 005.4.2.1.3.2 PRIMER BATCH: 5135773 (grey)

230 - Identify as per dwg & Stock Location: _____

240 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M301S16GA	301 SS Sheet 1/2 Hard	1.7600 sf (.176 ea)	100-Waterjet - Flow - 1	171143

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M301S16GA	2	30	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unr ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	MRB (QSI042) Approval
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Description Work Order Deviation 	By _____ Supervisor rification Coordinator roval ned Wrong le Dimensions Under tolerance ncorrect Lost/Missing Moved
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Part: D5600-1
 Job No: 185592
 Serial No/ Batch: S123852
 Revision: A
 Inspector: A
 Exp Date: _____
 Instructions: Various STC's
 Date: 11/01/18

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td><td>Pressure/F</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td><td>Bending</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td><td>Centre Not Correct</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td><td>Cracks</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td><td>Cuffs</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td><td>Crushing</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td><td>Heat Treat</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td><td>Marks/Chatter</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td><td></td><td></td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td><td>OTHER :</td><td></td></tr> </table>		Environment	☐	No Re-verification	☐	Pressure/F	☐	Design	☐	Operator	☐	Bending	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Correct	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Past Expiry Date	☐	Manufacturing Process	☐			Misidentified	☐	Past Due	☐	OTHER :		<table> <tr><td>Broken/Unqualified</td><td>☐</td></tr> <tr><td>Inspection Incomplete/Unqualified</td><td>☐</td></tr> <tr><td>Contamination</td><td>☐</td></tr> <tr><td>Countersink</td><td>☐</td></tr> <tr><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Instructions Incomplete/Unclear</td><td>☐</td></tr> <tr><td>Drill Holes</td><td>☐</td></tr> <tr><td>Out of Sequence</td><td>☐</td></tr> <tr><td>Off-set</td><td>☐</td></tr> <tr><td>Mislabeled</td><td>☐</td></tr> <tr><td>Fit/Function</td><td>☐</td></tr> <tr><td>Misaligned/off center</td><td>☐</td></tr> </table>	Broken/Unqualified	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	<table> <tr><td>Drawing</td><td>☐</td></tr> <tr><td>Finish</td><td>☐</td></tr> <tr><td>Misread</td><td>☐</td></tr> <tr><td>Turning Sequence</td><td>☐</td></tr> </table>	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
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Specifications could not be found.

Plex 10/31/18 7:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

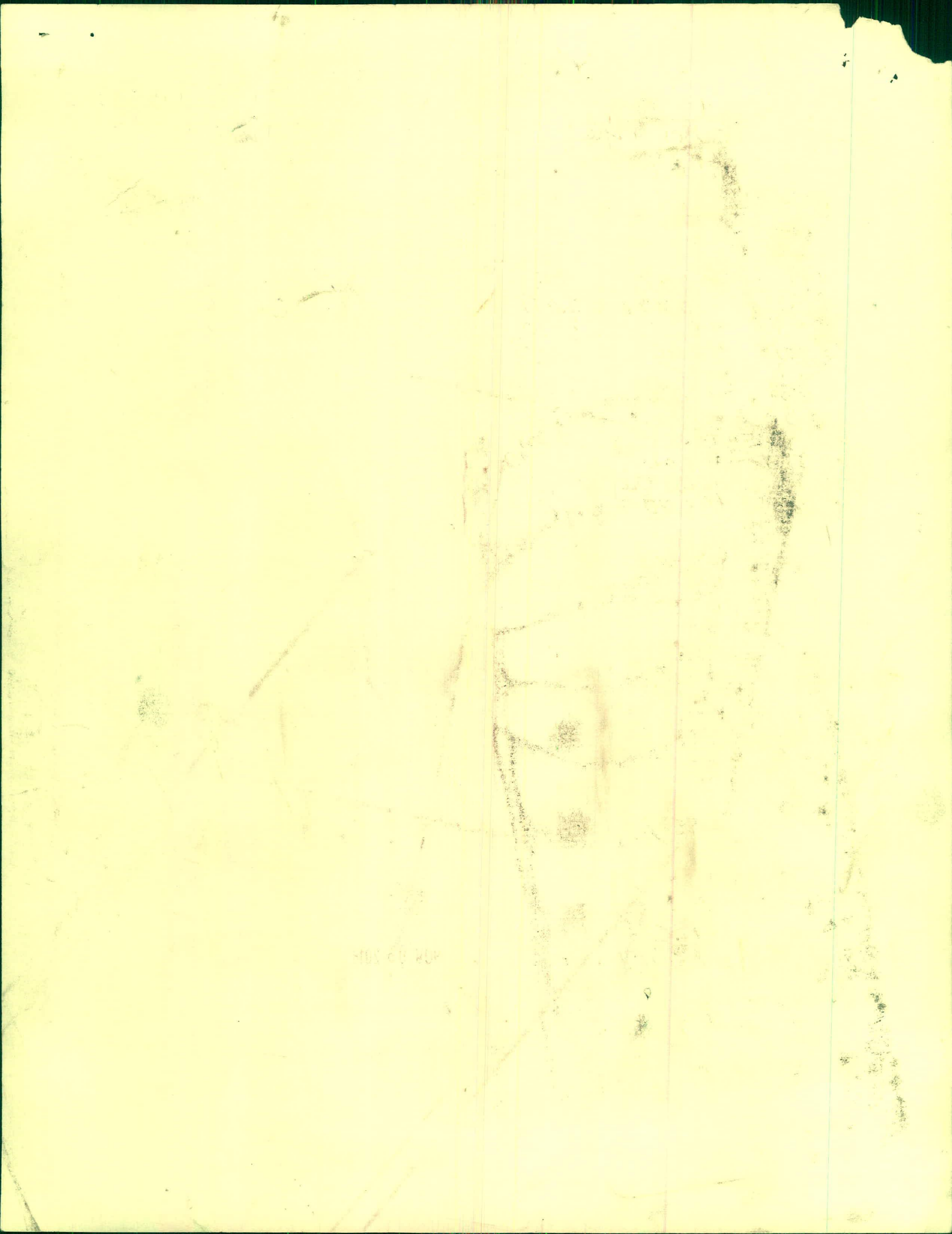


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

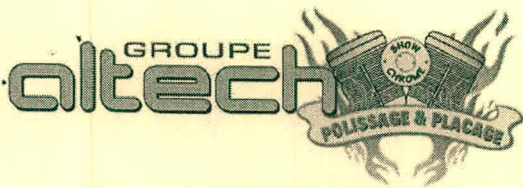
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								





Plex 12/10/18 8:38 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015153-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015153 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-Dec-2018		Aman		041979				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	D5600-1 Rev.	D5600-1 01 -PASSIVATION-BICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvant if required remove any markings, paintor and heavy contaminants. TERRY LINE	PASSIVATION CH	10	10	0	0	0

DAS
68
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

